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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D139-816-011
Job Sheet 201700



Part No: D139-816-011

Job Qty: 1 pcs

Part Name: Lightweight Interior Ceiling Panels



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Due Date: 11/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9686 REV A , DSI9691 REV A , IIN-D139-816 REV D SHEET 27 IPP Rev A 12/05/07 New Release
DL IPP Rev. B 12/11/08 Update dwg. DL IPP Rev. C Dwg. Update 13/07/09 DL ver:DD IPP REV:D 13.12.23
AS PER IIN REV.D DD VER:JFS IPP REV E 14.04.01 AS PER DSI9686 JLM VERIFIED BY:DD IPP REV:F
19.05.14 AS PER CHGO07 DD VER:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		11/20/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3	✓	
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		

Oscar
(013000)

NOV 27 2019



Container No: S235145



Part: D139-816-011

Job No: 201700

Serial No/Batch: S235145

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH12-54 Issue i

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				Packaging 1 - 30	
				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
115 Rework	1 pcs	11/20/19	0.00 0.00	Rework - 1 - B4B	
120 QC 4	1 pcs	11/20/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	DAS
				QC 4 - 75	78
				QC 4 - 78	9-89
130 Packaging 3-1 - Stock - B4B	1 pcs	11/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
135 DC - 1 - B4B	1 pcs	11/20/19	0.00 0.00	DC - 1 - B4B	21
				DC - 2 - B4B	9-89
140 QC 21 - FG	1 pcs	11/20/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-89

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FG-DECK

Part Op 110 - (Pick Kit)

Descriptions: 115 - Re-Glue D4635-041 and D4634-043 replace D4638-1

120 - (QC4- 100% Inspect kits for completeness)

130 - Package as per PPP D139-816-011 Identify and Stock Location:

135 - (Document Control) Photocopy blue file & type labels as per PPP D139-816-011 CHG007

140 - (QC21- Final Inspection - Work Order Release)

0.13000

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
21 01-20-21-C3C	Stud	16 Ea (16 ea)	110-Packaging 1 - Pick Kit	S131219 ✓
50-008-2	Component	16 Ea (16 ea)	110-Packaging 1 - Pick Kit	S075168 ✓
AN970-3	Washer	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	S082331 ✓
BT1-SI-M	Tie Wrap	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	T128238-L ✓
BT3LM-L	Tie Wrap	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	S034047 ✓
CB200	Acrylic Adhesive, 3.5C	3 pcs (3 ea)	110-Packaging 1 - Pick Kit	S028254 ✓
CS125-1022-2A-08	Stud	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	T130277 ✓
D4634-041	Fwd. Center Ceiling Panel Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S234770
D4634-042	Middle. Center Ceiling Panel Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S234782
D4634-043	Aft. Center Ceiling Panel Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S234785
D4635-041	Fwd Ceiling Panel Assembly, LH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S234761
D4635-042	Fwd Ceiling Panel Assembly, RH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S234719
D4635-043	Aft Ceiling Panel Assembly, LH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S234619
D4635-044	Aft Ceiling Panel Assembly, RH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S234619
D4638-043	Receptacle Bracket Assembly	16 pcs (16 ea)	110-Packaging 1 - Pick Kit	S227470 ✓
D4638-11	Bracket	10 pcs (10 ea)	110-Packaging 1 - Pick Kit	S227470 ✓
D4638-5	Bracket	10 pcs (10 ea)	110-Packaging 1 - Pick Kit	S227470 ✓
D4638-7	Retainer Plate	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	S224993 ✓
D4638-9	Template	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	M24315 ✓
D4648-1	Template	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S0091067 ✓
D4653-041	Vent Manifold Assembly	6 pcs (6 ea)	110-Packaging 1 - Pick Kit	S032881(x2) ✓
D4653-11	Clamp	6 pcs (6 ea)	110-Packaging 1 - Pick Kit	S224933 ✓
D4654-7	Spacer	3 pcs (3 ea)	110-Packaging 1 - Pick Kit	S132061 ✓
D4712-043	Bracket Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	S021818 ✓
D4716-1	Duct Hose	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	S026828 ✓
D4716-3	Duct Hose	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	S135059 ✓
D4716-5	Duct Hose	6 pcs (6 ea)	110-Packaging 1 - Pick Kit	S135061 ✓
D4720-057	Ps7J1 Jumper	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S170275 ✓
D4720-063	Cabin Temp Sensor Jumper Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S170281 ✓
D4730-020-035	Velcro Strip 2.0W/ X 3.5L	24 pcs (24 ea)	110-Packaging 1 - Pick Kit	S134128 ✓
D5032-1	Doubler	16 pcs (16 ea)	110-Packaging 1 - Pick Kit	S226767 ✓
D5032-3	Doubler	16 pcs (16 ea)	110-Packaging 1 - Pick Kit	S226765 ✓
D5078-1	Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S012076 ✓
MS21042L3	Nut	35 Ea (35 ea)	110-Packaging 1 - Pick Kit	S28152 ✓
MS24694-S01	Screw	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	S155069 ✓
MS27039-1-75	Screw	21 Ea (21 ea)	110-Packaging 1 - Pick Kit	S144920 ✓
NAS1149D0013J	Washer	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	M134502-213 ✓
NAS1149D00332J	Washer	34 Ea (34 ea)	110-Packaging 1 - Pick Kit	S226269 ✓
NAS1149D00663J	Washer	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	S226269 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	2351-20-21-C3C	16	61	0
	50-009-2	16	128	0
	AN970-3	10	121	0
	BT1.5I-M	24	306	0
	BT3LH-L	12	423	0
	CB200	3	8	0
	CS125-1032-8AACR	2	34	0
	D4634-041	1	0	0
	D4634-043	1	0	0
	D4634-045	1	0	0
	D4635-041	1	0	0
	D4635-042	1	0	0
	D4635-043	1	0	0
	D4635-044	1	0	0
	D4636-043	16	18	0
	D4636-11	10	15	0
	D4636-5	16	41	0
	D4636-7	4	1	0
	D4636-9	1	2	0
	D4648-1	1	3	0
	D4653-041	6	2	0
	D4653-11	6	14	0
	D4664-7	3	14	0
	D4712-043	2	8	0
	D4716-1	2	12	0
	D4716-3	4	12	0
	D4716-5	6	17	0
	D4728-057	1	9	0
	D4728-063	1	9	0
	D4730-020-035	24	104	0
	D5032-1	16	28	0
	D5032-3	16	31	0
	D5078-1	1	11	0
	MS21042L3	35	3,084	0
	MS24694-S51	36	233	0
	MS27039-1-15	21	191	0
	NAS1149D0316J	5	209	0
	NAS1149D0332J	34	1,145	0
	NAS1149D0663J	6	135	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Skid-tube ☐ Prod. Eng. Coord. ☐ Machining ☐ Rec/Store/Packaging ☐ Large Fab ☐ Finishing ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042) ☐	
Date: _____		Sequence #: _____		QTY Affected: _____		MIRB (QS1042)	
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY			
				Contamination ☐ Power Loss/Surge ☐ Misaligned/off center ☐ Folio/Program ☐ BOM/Route ☐ Grain Direction ☐ Broken/Damage/Defect ☐ Weld ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Drill Holes ☐ Out of Sequence ☐ Fit/Function ☐ Off-set/Set-up ☐			
				Other/Details: _____			
Completed By _____				Lead hand / Supervisor _____			
QC / QA Coordinator _____				_____			

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D139-816-011	INTERIOR CEILING PANEL KIT
1	D4634-041	FWD, CENTER CEILING PANEL ASSEMBLY
1	D4634-141	* FWD, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-040	MIDDLE, CENTER CEILING PANEL ASSEMBLY
1	D4634-143	* MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-045	AFT, CENTER CEILING PANEL ASSEMBLY
1	D4634-145	* AFT, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-041	LH, FWD CEILING PANEL ASSEMBLY
1	D4635-141	* LH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-042	RH, FWD CEILING PANEL ASSEMBLY
1	D4635-142	* RH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-043	LH, AFT CEILING PANEL ASSEMBLY
1	D4635-143	* LH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-044	RH, AFT CEILING PANEL ASSEMBLY
1	D4635-144	* RH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
10	D4636-043	RECEPTACLE BRACKET ASSEMBLY
10	D4636-14	BRACKET
10	D4636-5	BRACKET
4	D4636-7	RETAINER PLATE
1	D4636-9	TEMPLATE
1	D4648-1	TEMPLATE
6	D4653-041	VENT MANIFOLD ASSEMBLY
6	D4653-11	CLAMP
3	D4664-7	SPACER
2	D4712-043	BRACKET ASSEMBLY
2	D4716-1	DUCT HOSE
4	D4716-3	DUCT HOSE
3	D4716-5	DUCT HOSE
1	D4728-057	HARNESS ASSEMBLY
1	D4728-063	HARNESS ASSEMBLY
24	D4730-020-035	VELCRO STRIP
16	D5032-1	DOUBLER
16	D5032-3	DOUBLER
16	Z551-20-21-C3C	DZUS SCREW
16	50-009-2	GROMMET
10	AN970-3	WASHER
24	BT1.5I-M	TIE WRAP
12	BT3LH-L	TIE WRAP
1	CB 203	3.5g ACRYLIC ADHESIVE
2	CS125-1032-8-AA-CR	STUD (or CS125-1032-8-AA-CRM)
36	MS21042L3	NUT
36	MS24694-S51	SCREW
21	MS27039-1-15	SCREW
5	NAS1149D0316J	WASHER (or AN960JD10L)
34	NAS1149D0332J	WASHER (or AN960JD10)
6	NAS1149D0663J	WASHER (or AN960JD616)

NOTES:

(*) DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE
D4634-141/-143/-145 ARE REPLACEMENT PANELS
D4635-141/-142/-143/-144 ARE REPLACEMENT PANELS

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Revision: D
Date: 13.12.16

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to install the D5078-1 Bracket to support the Overhead Connector for D139-811-011 Interior Ceiling Panel Kit.

2.0 PROCEDURE

This procedure is added after step 3.1.39 of IIN-D139-816 Rev. D.

- 2.1 Position the D5078-1 Bracket on the LH side of the cabin overhead by temporarily removing 2x MS27039-1 screws as shown in Figure 1. Transfer 2x $\varnothing 0.204$ " (#6 drill) holes from airframe to the D5078-1 Bracket. Deburr and touch-up holes with MIL-P-85582 or MIL-P-23377 primer.
- 2.2 Install D5078-1 Bracket using existing 2x MS27039-1 screws and washers as shown in Figure 1.
- 2.3 Install overhead cannon plug in the D5078-1 Bracket using existing NAS1801/1802 screws and existing AS85049/95-20A-A Perimeter Mounting Flange as shown in Figure 2.
- 2.4 Reconnect wire harness to overhead cannon plug as shown in Figure 2.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

The D5078-1 bracket has been added to D139-816-011 Kits at CHG 005 and later. Customers who wish to obtain the D5078-1 Bracket for a kit that has already been installed can procure the DSI 9691-011 kit from Dart as outlined below.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9691-011	BRACKET KIT
1	D5078-1	BRACKET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

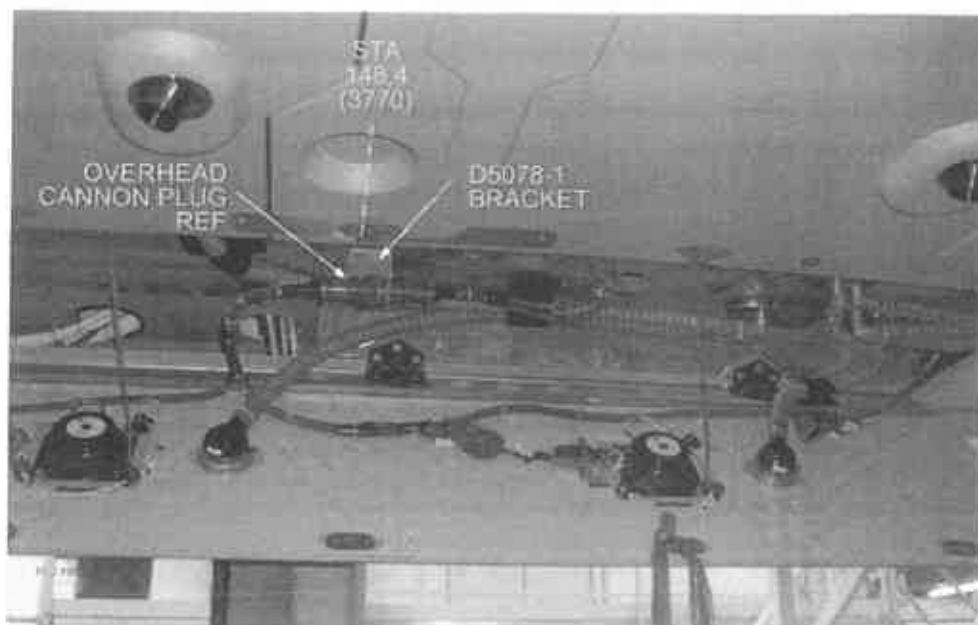


Figure 1. - LH Side Overhead Panel

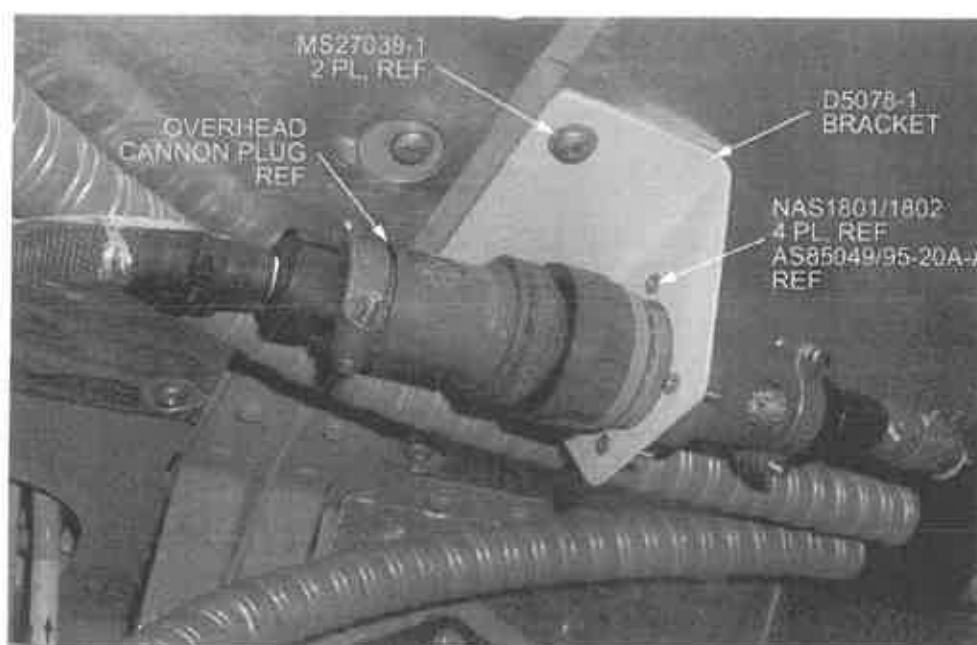


Figure 2. - D5078-1 Bracket Installation

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide an alternate method of installing the D139-816-011 Interior Ceiling Panel Kit for customers with newer 300 series aircraft models with split center ceiling panels.

2.0 PROCEDURE

This procedure modifies step 3.1.7 of IIN-D139-816 Rev. D.

- 2.1 Position the D4634-041/-043/-045 center panels onto the p/n E4417F01 cabin isolation mounts using $\varnothing 0.25"$ (6 mm) holes in the panels. Identify those mounts that do not align with holes in the panels. Ensure that a gap between the D4634-041/-043/-045 panels of approximately 0.050" (1.3 mm) is maintained.
- 2.2 Remove extra and non-aligning cabin isolation mounts from the ceiling. Temporarily install the removed mounts into non-align holes in the panels and paint mark the back of the E4417F01 mounts. Position the D4634-041/-043/-045 center panels onto p/n E4417F01 cabin isolation mounts. Ensure the new mount locations get marked in the cabin roof. Remove panels keeping the mounts on the panels.
- 2.3 Remove ceiling insulation from aircraft ceiling at the new marked mount locations.
- 2.4 Apply a small amount of CB 200 Click Bond adhesive to the E4417F01 cabin isolation mounts that are being relocated.
- 2.5 Reposition the ceiling panels on the ceiling pressing the E4417F01 cabin isolation mounts firmly on the ceiling and holding in position until the adhesive cures enough to remove the screws from the mount.
- 2.6 Install the necessary rivets to re-fasten the E4417F01 cabin isolation mounts to the ceiling.
- 2.7 Continue the ceiling panel installation as indicated in the IIN-D139-816.

3.0 GENERAL NOTE

- 3.1 Due to the thermoforming process variations in material thickness may occur. It is acceptable to install longer or shorter Dzus fasteners as required to accommodate this material variation.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

For D139-816-011 & CHG 005 and later, the following parts have been added to the kits.

QTY. -011	PART NUMBER	DESCRIPTION
X	D139-816-011	INTERIOR CEILING PANEL KIT
3	CB 200	3.5g ACRYLIC ADHESIVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ALTERNATE INSTALLATION	NTS
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